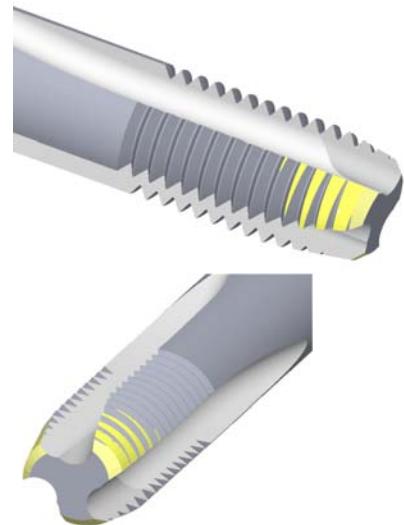


Tap M2 Z3

A10-020

In the manufacturing cycle is included the dressing cycle for the conventional wheel for fluting and threadfinishing. An inverse calculation for the flutewheelshape based on graphical input of the fluteform is available.



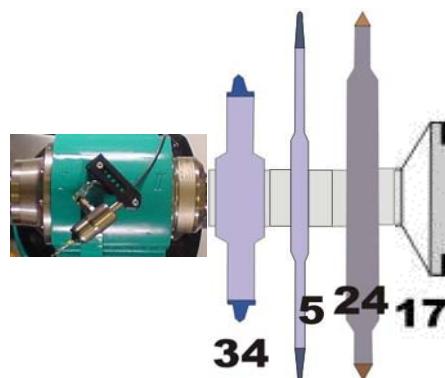
1. Cycletime for Production

Tool specifications							
M2, Length 10 mm, flutelength 13, Helix 30°							
Material HSS							
Operations							
Feed [mm/Min]	1000	180	200	1700	1700	100	100
Power [kW]	4	2	1	1	1	1	1
Cutting feed [m/s]	46	40	32	48	48	24	24
Used wheels							
Grinding time [s]	84	54	65	38	35	3	3
Total cycle time	4 Min 41						

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

34 Ø175 DXF A120
17 Ø125 12A2 B126
5 Ø150 14E1 A120
24 Ø125 14E1 A220



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR, dressing unit
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 - 7 bar
Software: Quinto 5

responsible engineer: OP,20.5.08

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TECHNOLOGY
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